

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011637**Date Inspected:** 21-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Trial Assembly Area

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 7AE to 7BE Side plate Stiffener to Stiffener , weld No. OBE7B-002. The welder is identified as #220067. ZPMC QC is identified as Mr. Wu Zhi Cheng. The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U4b-F.

SMAW in the 3G position for the OBG Segment 7BE deck plate to stiffener , weld No.DP-663-001-021. The welder is identified as #066481. ZPMC QC is identified as Mr. Wu Zhi Cheng. The welding variables recorded by QC appear to comply with WPS-B-T-3213-B-U3b.

SMAW in the 3G position for the OBG Segment 7BE deck plate to stiffener , weld No.DP-655-001-019. The welder is identified as #066480. ZPMC QC is identified as Mr. Wu Zhi Cheng. The welding variables recorded by QC appear to comply with WPS-B-T-3213-B-U3b.

SMAW in the 3G position for the OBG Segment 6CE Floor beam to Longitudinal Diaphragm , weld No. SEG-032D-013. The welder is identified as #037743. ZPMC QC is identified as Mr. Wu Zhi Cheng. The welding

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variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG Segment 6CE Floor beam to Longitudinal Diaphragm , weld No. SEG-032D-001. The welder is identified as #068764. ZPMC QC is identified as Mr. Wu Zhi Cheng. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 2G position for the OBG Segment 6BE Deck Plate to Edge Plate for repair , weld No.CA028-002, 004 and 006. The welders are identified as #049339 and #048047. ZPMC QC is identified as Mr.Tang Ya jun. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The weld repair report was B-CWR-1137.

SMAW in the 2G position for the OBG Segment 6AW Deck Plate to Edge Plate for repair , weld No.CA025-004. The welders are identified as #045221 and #045196. ZPMC QC is identified as Mr.Tang Ya jun. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The weld repair report was B-CWR-1078.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
